

# Work Order ID 55144

January 7, 2010 8:44:02 AM



Page 1

Item ID: D3281-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Afr RH

Start Date: 07/01/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 10-1-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3281

Rev D

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

BB  
10/01/21  
X10

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3281 Hand Folio FTA 010 Dwg. Rev.  
D Folio Rev.

BB  
10/01/21  
X10

120

0.00



QC2- Inspect parts off machine FAI/FAIB


QC

Memo

0.00

Quality Control

BB  
10/01/21  
X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.01.21	130	ACCEPTABLE TO CUT AT 0.95". LEAVE OUT BEVEL.				 10.01.21 QS1042	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55144

January 7, 2010 8:44:02 AM



Page 2

Item ID: D3281-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH

Start Date: 07/01/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

BB  
10/01/21  
X10

140



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

BB  
10/01/21  
X10

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

⇒ S1010.66

X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 55144

January 7, 2010 8:44:02 AM



Page 3

Item ID: D3281-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector, Aft RH

Start Date: 07/01/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

0.00



Packaging

Packaging

Memo

0.00

Packaging

10-1-27 (10x) SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27 HJ

MF 10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 7, 2010 8:44:07 AM

Page 1

Work Order ID: 55144

Parent Item: D3281-4

Parent Item Name: Floor Protector, Aft RH

Start Date: 07/01/2010

Required Date: 15/01/2010

Comments: IPP Rev A 04.07.01 New issue KJ/JLM  
IPP Rev B 07.08.07 Thermoform in house DL  
Ext. Rev C 08.02.06 to reflect updated Dwg. DL  
IPP Rev D 08.04.15 Material Change DL

Start Qty: 10.03

Required Qty: 10.03

MLEXS.093-F6006-02

Purchased

No

100

sf

1,376.930 43.3300



GE PLASTICS LEXAN SHEET

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1376.93

106751

6.26

110877

1370.67

BB  
10/01/21  
X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 55144
<b>Description:</b> Floor Protector, Aft RH		<b>Part Number:</b> D3281-4
<b>Inspection Dwg:</b> D3281	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 0.1875"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

<b>Measured by:</b> JB	<b>Date:</b> 10/01/21
------------------------	-----------------------

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.8	+/-0.100	17.730	✓			
17.1	+/-0.100	17.1	✓			
14.3	+/-0.100	14.33	✓			
0.95	+/-0.030	.962				
0.25	+/-0.030		N/A			
3.1	+/-0.100		N/A			
0.050	Min	.058	✓			
0.070	Min	.081	✓			

<b>Measured by:</b> JB	<b>Date:</b> 10/01/21
<b>Audited by:</b> BL	<b>Date:</b> 10/01/21
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	

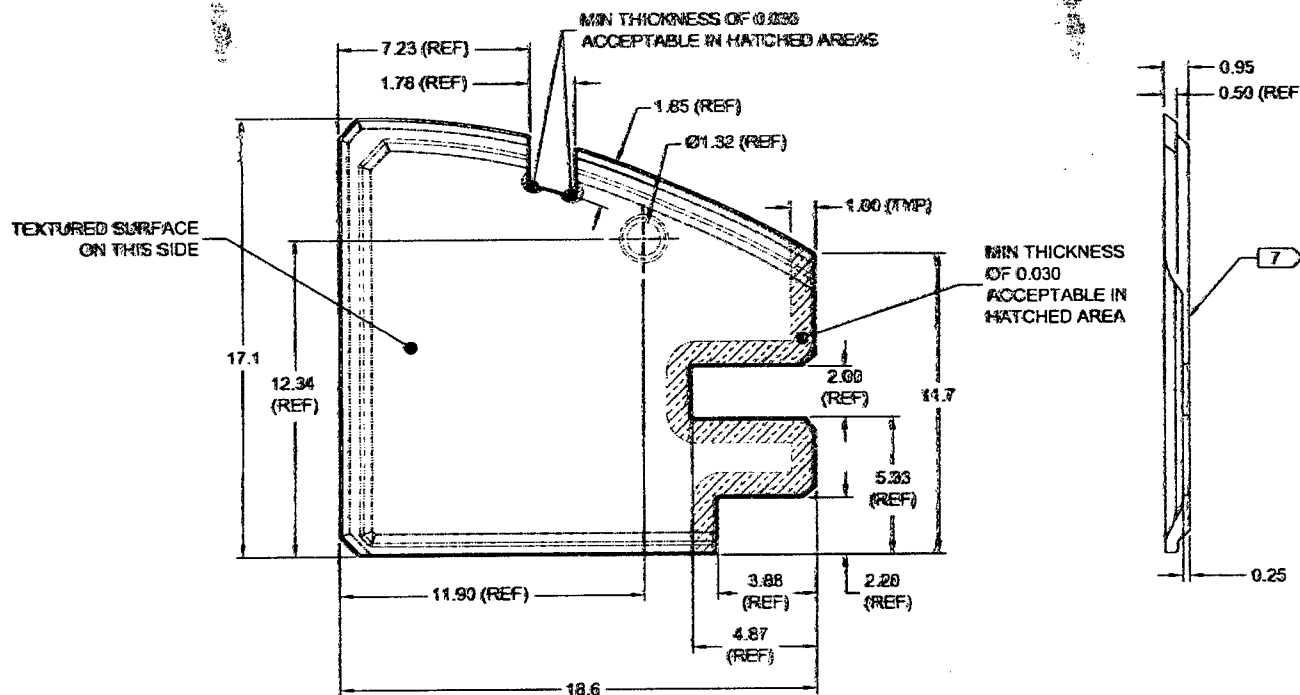
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

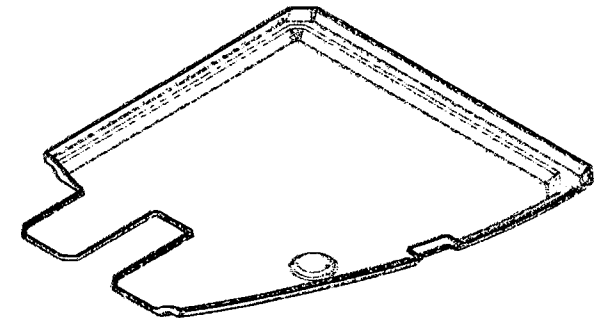
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3281-1 FLOOR PROTECTOR**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55144  
BA 10-1-07

105-0411 WPD

**81-1 NOTES:**  
HERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN  
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
(REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.010 MAX  
IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" AND BATCH NUMBER "8XXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS  
WEIGHT: 0.95 lb

REV.	DESCRIPTION	BY	DATE
D	THICKNESS 0.093 WAS 0.125, MIN THICKNESS 0.070 WAS 0.080, P/N AND B/N ID WITH VIBRATING STYLUS (ZN A7-1, A7-2, A7-3, A7-4); D3281-1 NOW ON PAGE 4; CORRECT WEIGHTS (ZN A8-1, A8-2, A8-3, A8-4)	PH	08.03.28
C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
DESIGN	DRAWN	DATE	08.03.28
CHECKED	BY	DATE	08.03.28
MFG. APPR.	BY	DATE	08.03.28
APPROVED	BY	DATE	08.03.28
DE APPR.	BY	DATE	08.03.28
DATE	08.03.28	DATE	08.03.28

**DART AEROSPACE LTD**  
HARRISBURG, ONTARIO, CANADA

DRAWING NO. **D3281** REV. **D**  
SHEET 1 OF 4

TITLE **FLOOR PROTECTOR** SCALE **NTS**

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**Dart Aerospace Ltd**

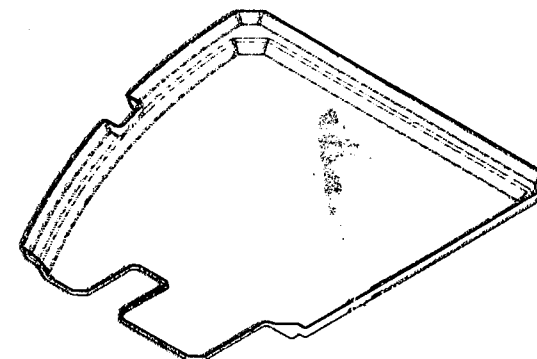
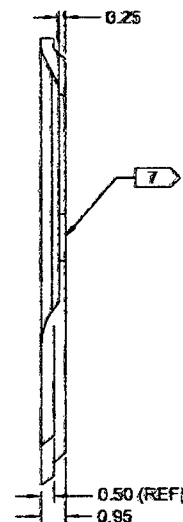
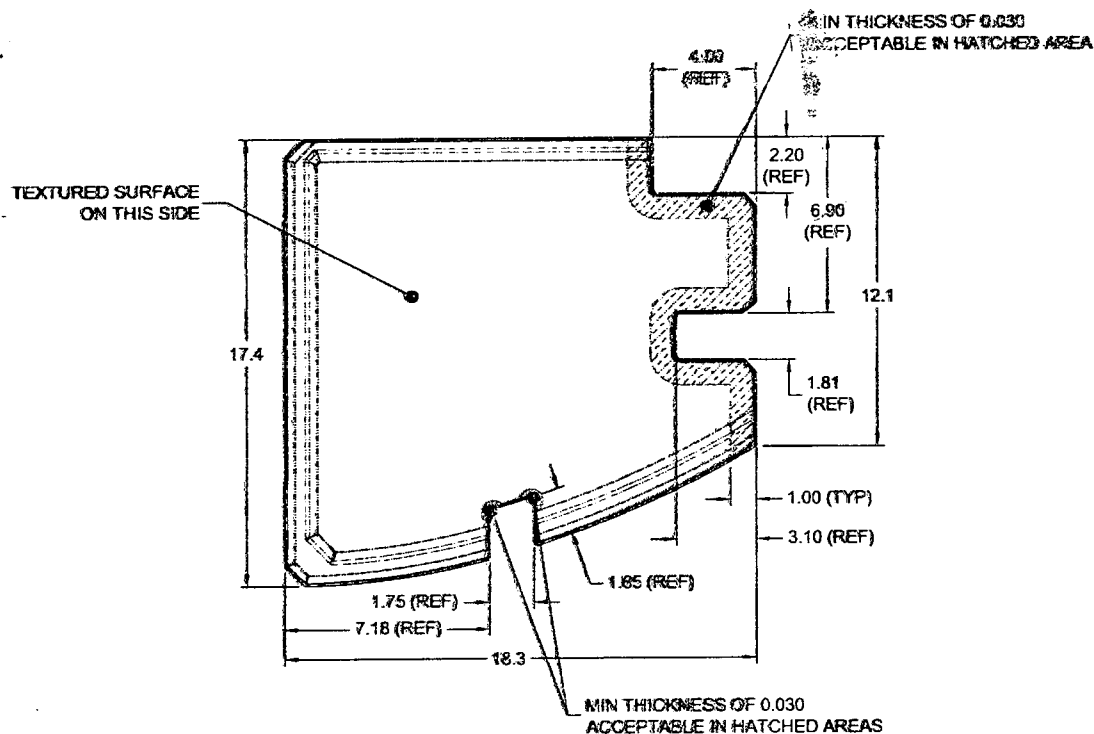
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D3281-2 FLOOR PROTECTOR**

**NOTES:**  
 1. THERMOFORM WITH MOLD D3281-2T1 PER DART QSI Q22; TRIM AS SHOWN  
 2. MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
 3. MATERIAL: LEXAN F6006, BLACK No. 701, 0.083" THICK  
 (REF DART SPEC MLEXS.093-F6006-02)

FINISH: NONE  
 TOLERANCES: PER DART QSI Q18 UNLESS OTHERWISE NOTED  
 UNITS: INCHES UNLESS OTHERWISE NOTED  
 BREAK SHARP EDGES: 0.010 MAX  
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-2" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS  
 WEIGHT: 0.97 lb

08.11.04/100  
 W/O 55144

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3281	SHEET 2 OF 4
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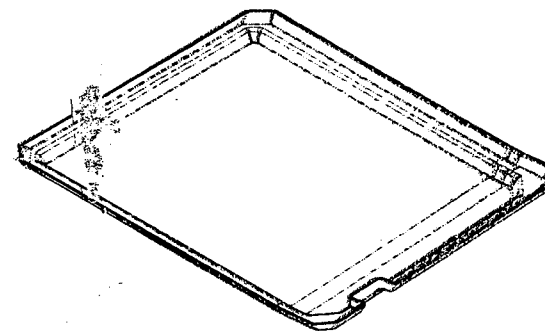
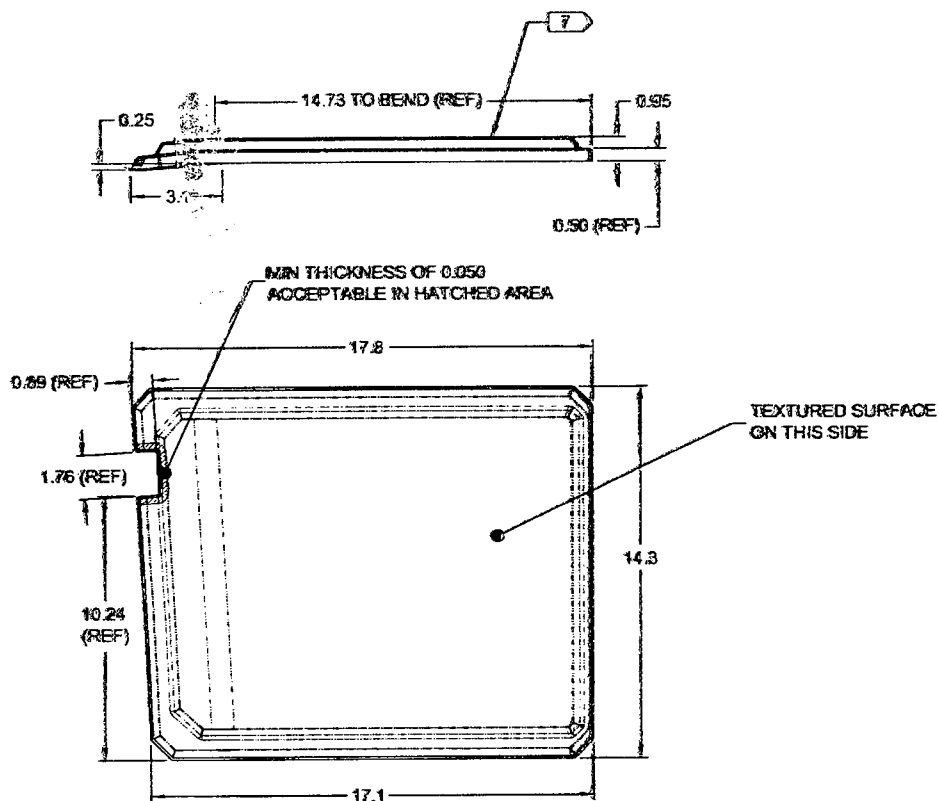
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



### D3281-3 FLOOR PROTECTOR

**281-3 NOTES:**  
 THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN  
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
 MATERIAL: LEXAN F6006, BLACK No. 701, 0.093" THICK  
 (REF DART SPEC MLEXS 093-F6006-02)

FINISH: NONE  
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 UNITS: INCHES UNLESS OTHERWISE NOTED  
 BREAK SHARP EDGES: 0.010 MAX  
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-3" AND BATCH NUMBER "BXXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS  
 WEIGHT: 0.87 lb



DESIGN	W/D	<b>DART AEROSPACE LTD</b>	
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MFG. APPR.	W/D	D3281	SHEET 3 OF 4
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

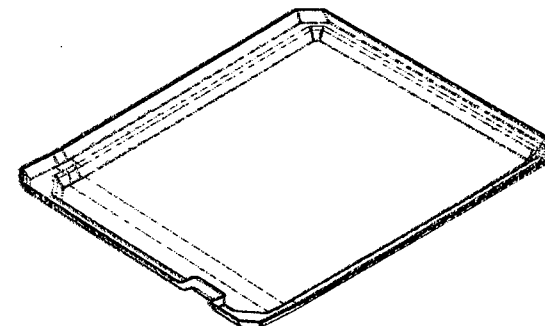
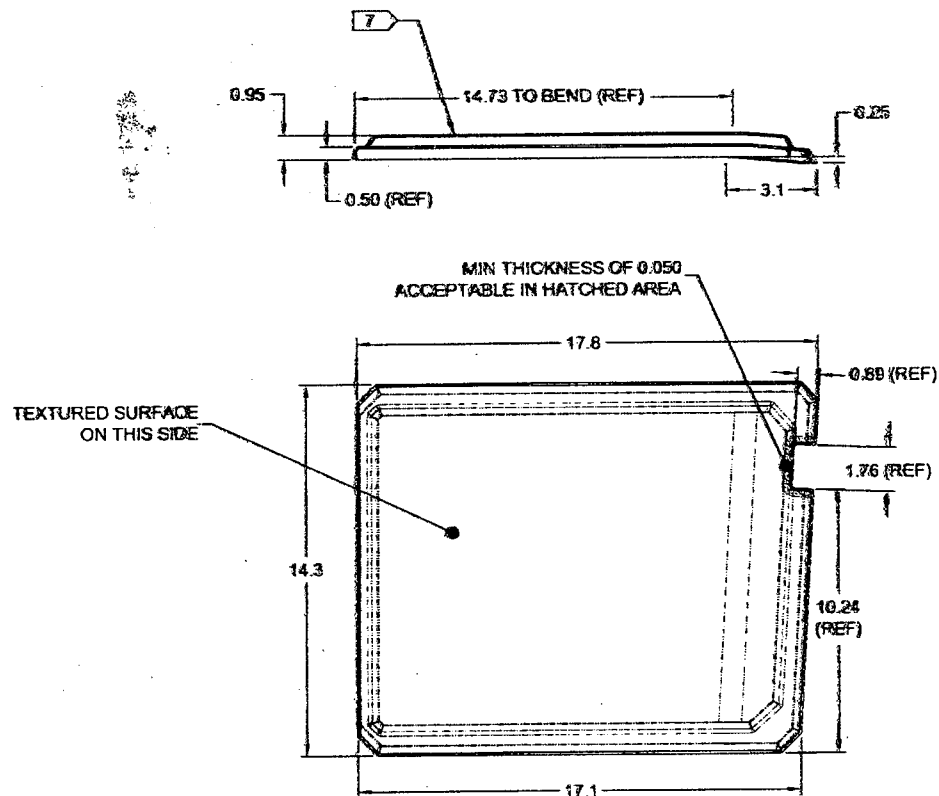
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





# **D3281-4 FLOOR PROTECTOR**

## **21-4 NOTES:**

HERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN  
 MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED  
 MATERIAL: LEXAN F8006, BLACK No. 701, 0.093" THICK  
 (REF DART SPEC MLEXS.053-F8006-02)

FINISH: NONE

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.010 MAX

IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-4" AND BATCH NUMBER "8XXXXX" ON SMOOTH SIDE OF PART USING VIBRATING STYLUS

WEIGHT: 0.67 lb

W/B 55144

DESIGN	00	<b>DART AEROSPACE LTD</b>	
DRAWN	AF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AF	DRAWING NO. 03281	REV. D
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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